Work Order ID 69875

Tuesday, May 24, 2011 8:26:00 AM

Item ID: D350-636-012 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Skidtube RH

Start Date: 5/24/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 5/30/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** [signature] **Date:** 11-05-24 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	DOCUMENT CONTROL	0.00							
DC	**Memo**	0.00							
Document Control	Photocopy blue file and type labels per PPP D350-636-012 CHG 006								

Draw Nbr	Revision Nbr
D2750	F
D3492	C

[signature] 5/26/16

[signature] for BG 11-6-16

69875

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Item ID: D350-636-012 **Accept** **Setup Start**
Revision ID: **Stop**
Item Name: Skidtube RH

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Required Date: 5/30/2011 **Req'd Qty:** 1.00 **Customer:**
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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
Skidtubes	Skidtubes								
Skidtubes	**Memo**	0.00							

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details).Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***

8-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

BB 11/05/28

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch:□ M116577 BE 11/05/30								
	12-Grind welds flush as per Dwg D2750 BE 11/05/30								
120 QC Quality Control	QC10- Inspect visual per QSI004- ground welds **Memo**	0.00 0.00							
130 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00							

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	**Memo**	0.00							
Hand Finishing									11/05/31
150	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							11-5-31
Quality Control									

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
Skidtubes		0.00							
Skidtubes									

Memo

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

DL 11/05/31

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015
A/R ☐Sikaflex-291 batch: 11695☐☐☐
exp. date: 12/01/15

BB 11/05/31

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)
A/R☐ Aluminum Rod batch: M117456

BE 11/06/06

9- At section AP-AP drill out x-bolt spacer to 0.404"

BE 11/06/06

10-Grind welds flush as per Dwg D2750

BB 11/06/07

11-Spot face ground handling holes section (total of 4 places per side) as per

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	dwg D2750								
	12-Deburr holes		BB						11/06/07
170 QC Quality Control	QC10- Inspect visual per QSI004- ground welds	0.00	8/6/08						
	Memo	0.00							
180 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00	8/6/08			(H)			
	Memo	0.00							

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00				1X	Ø	M-L	11/06/14
HandFinish	**Memo**	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				1X	Ø	M-L	11/06/14
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 1:10 OVEN TEMPERATURE: 320 01= FINISH TIME: 1:40								
M1116964									
210	QC3- Inspect Part Finish	0.00				1		BR 11-6-15.	
QC	**Memo**	0.00							
Quality Control	Inspect for foreign object per QSI 024								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
HandFinish	HandFinishing								
Hand Finishing	**Memo** Install inserts as per dwg D2750	0.00				1			BL 11-6-15
230		0.00							
HandFinish	HandFinishing								
Hand Finishing	**Memo**	0.00				1			BL 11-6-15.

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"
batch: _____

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750
SIKA FLEX 241
BATCH: 117516
EXP DATE: 15-01.

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: 114184

5-Coat all exposed fasteners with "LPS Procyon"
batch: 114596

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00				8 6/6/16			
250 Packaging Packaging	Pick Kit **Memo**	0.00 0.00				6/6/16 SP			
260 QC Quality Control	QC4- 100% Inspect kits for completeness **Memo**	0.00 0.00				8 6/6/16			

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	Packaging	0.00							
Packaging									
Packaging	**Memo**	0.00							
Packaging	Package as per PPP D350-636-012								
280	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

Rec'd 11/6/17

11/6/20

CMF 11-06-17

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Picklist Print

Tuesday, May 24, 2011 8:26:07 AM

Work Order ID: 69875

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 5/24/2011 **Required Date:** 5/30/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev:I□02.09.25□Rearranged procedure steps□KJ□
IPP Rev:J 06-03-29 As per Rev D EC
IPP Rev:K 06-07.13 As per dsi9343 EC
IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as per
IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-225		Purchased	No			220	Each	1,617.000	38	38			
Insert													
				Location		**Loc Qty**		**Loc Code**					
				ST282		1617							
					110768	817							
					117717	800				38. BR 11-6-15			
AN3C5A		Purchased	No			230	Each	1,586.000	34	34			
Bolt													
				Location		**Loc Qty**		**Loc Code**					
				FP-A		7							
					115835	7							
				ST350		1579							
					115422	49							
					116419	334							
					116549	96							
					117343	500							
					117508	300				34 BR 11-6-15.			
					117764	300							

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Parent Item Name: Skidtube RH

Start Date: 5/24/2011 **Required Date:** 5/30/2011

Start Qty: 1.00 **Required Qty:** 1.00

AN3C6A	Purchased	No		230	Each	410.0000	4	4
BOLT								

Location	Loc Qty	Loc Code
FP-A	1	
111982	1	
ST351	409	
111982	2	
116419	23	
116549	50	
116704	84	
117514	100	
117619	50	
117688	100	

4. BK 11-6-15

AN6C44A	Purchased	No		230	Each	113.0000	4	4
BOLT								

Location	Loc Qty	Loc Code
FG	2	
103964	2	
ST344	111	
117407	80	
117763	31	

4 BK 11-6-15.

AN8C35A	Purchased	No		230	Each	69.0000	1	1
BOLT								

Location	Loc Qty	Loc Code
FP	40	
117511	40	
FP-A	29	
115960	6	
116874	23	

1 BK 11-6-15

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Tuesday, May 24, 2011 8:26:07 AM

Work Order ID: 69875

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 5/24/2011 **Required Date:** 5/30/2011

Start Qty: 1.00 **Required Qty:** 1.00

AN960C10L NAS1149C0332 R	Purchased	No		230	Each	0.0000	38	38	38. BR 11-6-15.
washer			117791						
AN960C816L	Purchased	No		230	Each	0.0000	1	1	1 BR 11-6-15.
WASHER			NAS1149C0832R 114915						
D2745	Manufactured	No		230	Each	206.0000	8	8	
Bushing									

Location	Loc Qty	Loc Code
FP-A	206	
67764	5	
68248 ✓	201	

8 BR 11-6-15.

D3488-042	Manufactured	No		230	Each	24.0000	1	1	
Blade Fitting Assembly, RH									

Location	Loc Qty	Loc Code
FP008	24	
62003	4	
65099 ✓	8	
68109	12	

1 BR 11-6-15.

D3492-1	Manufactured	No	69531	230	Each	0.0000	8	4	4. BR 11-6-15.
Plug									
D3492-3	Manufactured	No	69819	230	Each	0.0000	8	8	8. BR 11-6-15.
Plug			69822						

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Tuesday, May 24, 2011 8:26:08 AM

Work Order ID: 69875

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 5/24/2011 **Required Date:** 5/30/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3535-25	Manufactured	No		230	Each	30.0000	1	1
Wearshoe								

Location	Loc Qty	Loc Code	
FP018	30		
62233	1		
65167	3		
68353 ✓	11		
69284 ✓	15		1 BR 11-6-15

D3536-25	Manufactured	No		230	Each	34.0000	1	1
Gasket								

Location	Loc Qty	Loc Code	
FP012	34		
65903 ✓	8		
68351 ✓	26		1 BR 11-6-15.

D3537-1	Manufactured	No		230	Each	34.0000	3	3
Wearpad								

Location	Loc Qty	Loc Code	
FP017 ~~69857~~	34		
63313	2		
66804	28		
66935	4		3. BR 11-6-15.

D3631-1	Manufactured	No		230	Each	500.0000	8	8
Washer								

Location	Loc Qty	Loc Code	
ST072	500		
68062 ✓	500		8 BR 11-6-15.

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 8:26:08 AM

Work Order ID: 69875

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 5/24/2011 **Required Date:** 5/30/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3672-1 Phenolic Washer	Manufactured	No		230	Each	1,350.000	8	8

Location	Loc Qty	Loc Code
ST074	1350	
64177 ✓	850	
66821	500	

4 BR 11-6-15.

D3791-1 Wearplate	Manufactured	No		230	Each	19.0000	1	1

Location	Loc Qty	Loc Code
FP017	19	
62239 ✓	7	
68352 ✓	12	

1 BR 11-6-15

D3793-1 Wearshoe	Manufactured	No		230	Each	31.0000	1	1

Location	Loc Qty	Loc Code
FP018	31	
64445 ✓	14	
69285 ✓	17	

1 BR 11-6-15.

D3793-3 Wearshoe	Manufactured	No		230	Each	30.0000	1	1

Location	Loc Qty	Loc Code
FP018	21	
68356 ✓	13	
69283	8	
FP019	9	
64447	9	

1 BR 11-6-15

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID: 69875

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 5/24/2011 **Required Date:** 5/30/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3794-1	Manufactured	No		230	Each	32.0000	1	1
Gasket								

Location	Loc Qty	Loc Code
FP010	32	
39421	1	
61704	5	
68355 ✓	26	

1 BR 11-6-15.

D3794-3	Manufactured	No		230	Each	34.0000	1	1
Gasket								

Location	Loc Qty	Loc Code
FP010	26	
68357 ✓	26	
FP018	8	
39422	1	
61712	7	

1 BR 11-6-15

MS21043-6	Purchased	No		230	Each	523.0000	4	4
NUT								

Location	Loc Qty	Loc Code
FG	20	
103693	20	
FP-A	40	
112314 ✓	40	
ST301	463	
112314	463	

4 BR 11-6-15.

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Tuesday, May 24, 2011 8:26:08 AM

Work Order ID: 69875

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 5/24/2011 **Required Date:** 5/30/2011

Start Qty: 1.00 **Required Qty:** 1.00

MS21083C8	Purchased	No		230	Each	113.0000	1	1
NUT								

Location	Loc Qty	Loc Code
FP-B	1	
115884	1	
ST303	112	
115884	0	
117291 ✓	37	
117423	50	
117677	25	

1 BR 11-6-15.

NAS1611-010	Purchased	No		230	Each	266.0000	8	8
O-RING								

Location	Loc Qty	Loc Code
FP	80	
117460 ✓	80	
FP-A	186	
110915	139	
115589	47	

8 BR 11-6-15.

NAS1611-013	Purchased	No		230	Each	168.0000	8	8
O-RING								

Location	Loc Qty	Loc Code
FP	163	
117291 ✓	123	
117460 ✓	40	
FP-A	5	
116582	5	

117887

6. BR 11-6-15

2. BR 11-6-15.

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 8:26:09 AM

Work Order ID: 69875

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 5/24/2011 **Required Date:** 5/30/2011

Start Qty: 1.00 **Required Qty:** 1.00

AN8C21A	Purchased	No	250	Each	101.0000	2	2
BOLT							

Location	Loc Qty	Loc Code
ST344	25	
117764	25	
ST345	76	
116381	26	
117562	50	2

AN960JD816	Purchased	No	250	Each	43.0000	2	2
1/2" washer,Alum							

Location	Loc Qty	Loc Code
FP-A	43	
106043	43	2

D2741	Manufactured	No	250	Each	44.0000	1	
Blade, 350 Skidtube							

Location	Loc Qty	Loc Code
ST466	44	
61341	6	
63589	38	1

D3493-1	Manufactured	No	250	Each	72.0000	2	2
Washer							

Location	Loc Qty	Loc Code
ST062	72	
66975	31	
68253	41	2

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID: 69875
Parent Item: D350-636-012
Parent Item Name: Skidtube RH

Start Date: 5/24/2011 **Required Date:** 5/30/2011
Start Qty: 1.00 **Required Qty:** 1.00

D3532-1 Spacer	Manufactured	No	250	Each	35.0000	2	2

Location	Loc Qty	Loc Code	
ST065	35		
62218	13		
66949	22		2

MS21083C8 NUT	Purchased	No	250	Each	113.0000	2	2 11/6/11 GSF

Location	Loc Qty	Loc Code	
FP-B	1		
115884	1		
ST303	112		
115884	0		
117291	37		
117423	50		2
117677	25		

D2600-3-BENT Extrusion Bent	Manufactured	No	110	Each	14.0000	1	1

Location	Loc Qty	Loc Code	
LG	14		
~~66875~~	8		
68137	6		1

BB 11/05/28

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID: 69875

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 5/24/2011 **Required Date:** 5/30/2011

Start Qty: 1.00 **Required Qty:** 1.00

D2744 Cap	Manufactured	No	110	Each	26.0000	1	1	BE 11/25/30

Location	Loc Qty	Loc Code	
LG002	26		
62715	2		
65086	24		1

D2739 350 I Beam	Manufactured	No	160	Each	4.0000	1	1	

Location	Loc Qty	Loc Code	
LG 69538	4		1
67785	1		
68285	3		

BE 11/05/31

D2743 Crossbolt Spacer	Manufactured	No	160	Each	162.0000	8	8	BE 11/06/06

BE 68948 x8

Location	Loc Qty	Loc Code	
LG	63		
68948	63		
LG001	99		
67766	35		
68251	64		

D3490-3 Cross Bolt Spacer	Manufactured	No	160	Each	86.0000	4	4	BE 11/06/06

Location	Loc Qty	Loc Code	
LG	86		
68106	22		3
68952	64		

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 8:26:10 AM

Work Order ID: 69875

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 5/24/2011 **Required Date:** 5/30/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3490-1	Manufactured	No		160	Each	49.0000	4	4

Cross Bolt Spacer

BE 1/06/06

Location		Loc Qty	Loc Code	
LG		47		
	67773	5		
	68105	42		4
LG001		2		
	62450	2		

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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69875

11-05-24 RELEASED

GENERAL NOTES:

1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
2) FINISH:
 ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
8) WELD PER DART QSI 004
9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
 MINIMUM YIELD TENSILE STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL (F)
13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

REV.	DESCRIPTION	BY	DATE
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL), WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16

DESIGN	PH	**DART AEROSPACE USA, INC.**
DRAWN	RH	PORT HADLOCK, WA
CHECKED	AJ	DRAWING NO. D2750 REV. F
MFG. APPR.		SHEET 1 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
DE APPR.		
DATE	08.07.16	

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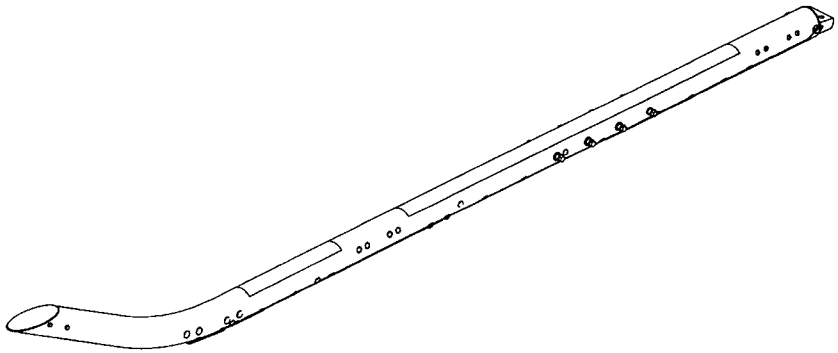
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

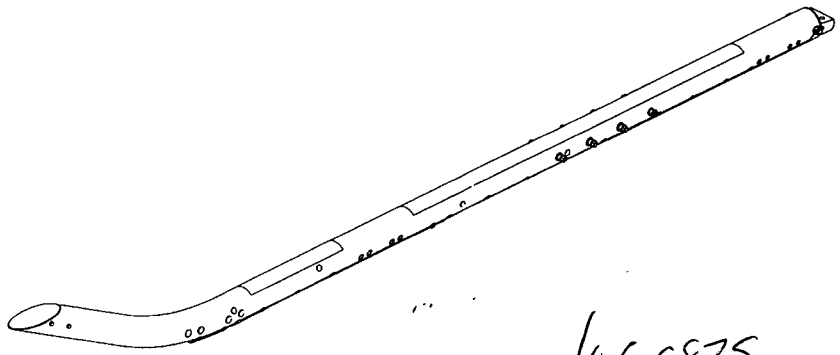
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries



D2750-041 350 SKIDTUBE ASSEMBLY, LH



W0669875

D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
08.9.22 AM

DESIGN		DART AEROSPACE USA, INC.
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. D2750 REV. F
MFG. APPR.		SHEET 2 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
DE APPR.		
DATE 08.07.16		

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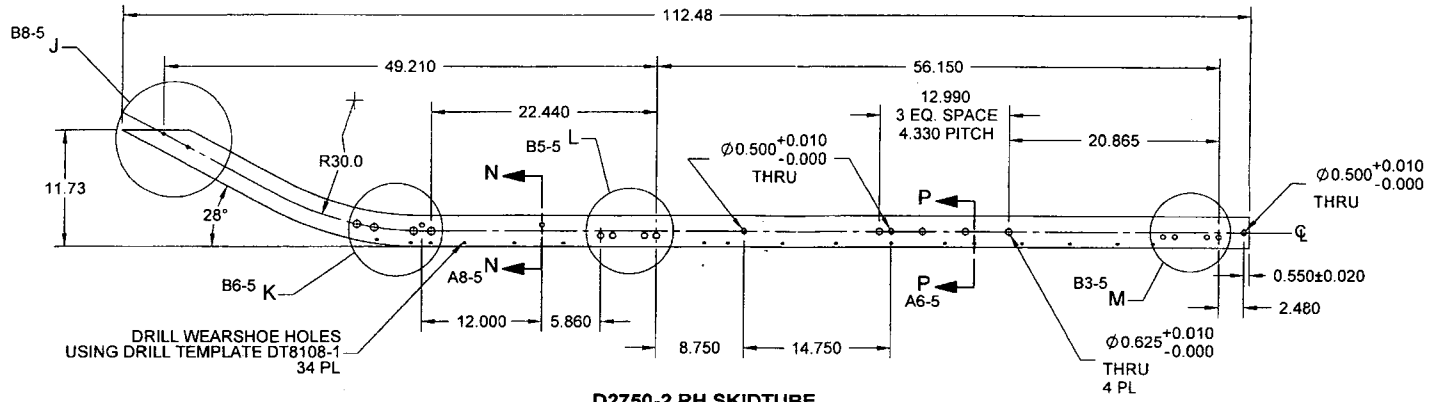
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

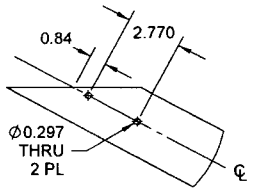
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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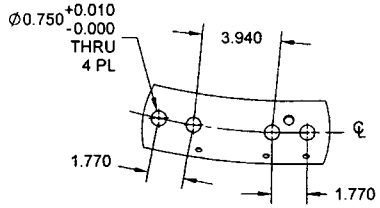


D2750-2 RH SKIDTUBE



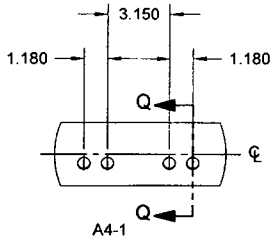
D8-5

DETAIL J
SCALE 2X



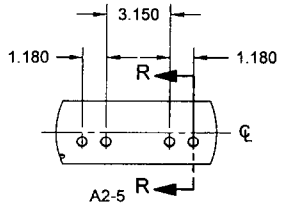
C7-5

DETAIL K
SCALE 2X



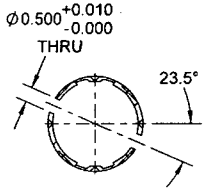
D6-5

DETAIL L
SCALE 2X



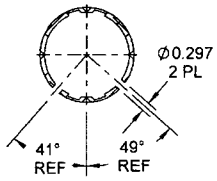
C3-5

DETAIL M
SCALE 2X



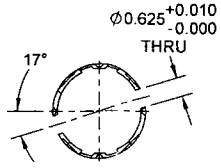
C6-5

SECTION N-N
SCALE 3X, 2 PL



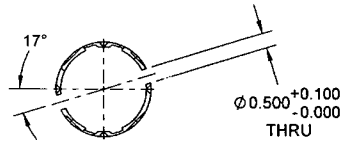
C4-5

SECTION P-P
SCALE 3X, 17 PL



B5-5

SECTION Q-Q
SCALE 3X, 4 PL



B3-5

SECTION R-R
SCALE 3X, 4 PL

u669875

RELEASED
Ø 9/22/16

DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D2750 REV. F
MFG. APPR.		SHEET 5 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
DE APPR.		
DATE 08.07.16		

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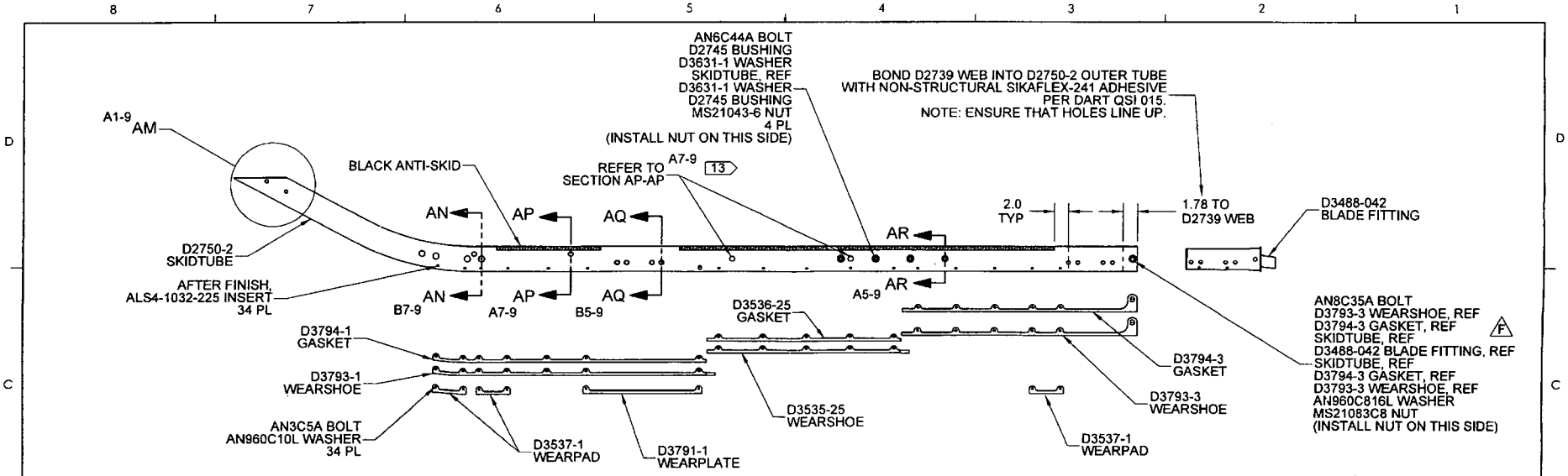
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

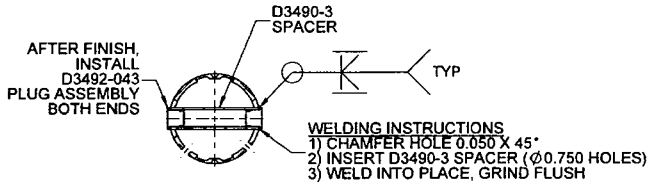
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

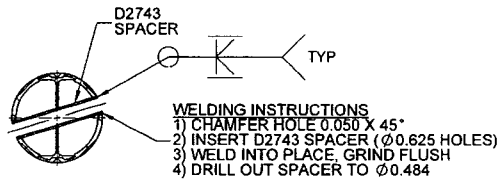


D2750-042 350 SKIDTUBE ASSEMBLY, RH

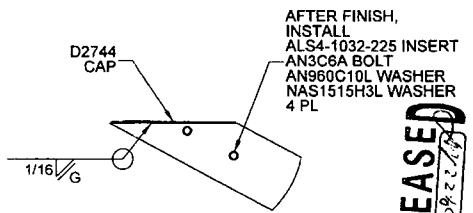
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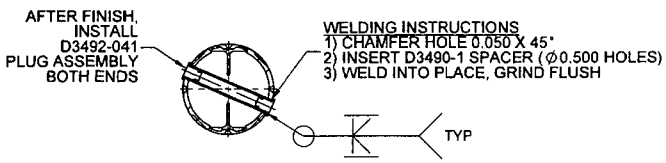
SECTION AN-AN
SCALE 3X, 4 PL



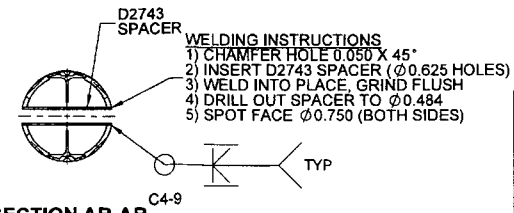
SECTION AQ-AQ
SCALE 3X, 4 PL



DETAIL AM
SCALE 2X



SECTION AP-AP
SCALE 3X, 4 PL



SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

RELEASED 08.22.16

DESIGN	PH	DART AEROSPACE USA, INC.
DRAWN	PH	PORT HADLOCK, WA
CHECKED		DRAWING NO. D2750 REV. F
MFG. APPR.		SHEET 9 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
DE APPR.		
DATE	08.07.16	

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W/O:		WORK ORDER CHANGES					
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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

NO. 254

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 698172
Part number: 1350 6366 011
Description: 350
Welding Process: Tig[X] Mig[]
Base materiel: aluminum
Current: AC[X] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[X]	fail[]
Penetration:	pass[X]	fail[]

UNACCEPTABLE

Cracks:	pass[X]	fail[]
Undercut:	pass[X]	fail[]
Pin holes:	pass[X]	fail[]
Overlap (cold lap)	pass[X]	fail[]
Porosity (surface):	pass[X]	fail[]
Coloration:	pass[X]	fail[]

Qualifier Pat Lewis **Date of Test Coupon** 11.06.08

Welder Barclay Elliot **Date of Test Coupon** 11/06/08

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries